

Date: Friday, 09/05/2008 1:53:19 PM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOOR ASSEMBLY
<b>Job Number</b> : 39169D	
<b>Estimate Number</b> : 12357	
<b>P.O. Number</b> :	<b>Part Number</b> : D41269404
<b>This Issue</b> : 09/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D412-694
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : C1
<b>Previous Run</b> : 36652D	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/06/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.05.09</u>	
<b>Comment</b> : Est Rev: A 05.12.09 New Issue    KJ/RF	
Est Rev: B 06.04.18 New dwg rev. ecn781    EC	
Est Rev: C 06.07.10 Revised per B24659    KJ	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL



JLD 08.8.26

**Comment:** DOCUMENT CONTROL

Issue red decal labels for D412-694-04. CHG005

2.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY

**Comment:** COMPOSITE ASSEMBLY

D412-694-04 Drill Process

1- Drill pilot holes Ø(#30) using Dwg Tool D3140-303A for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T11-T12 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference. \* 080618

2- Drill Pilot holes Ø(#30) using drill Jig D3120-4T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3. \* 080618

3- Drill Pilot holes Ø(#30) using drill Jig DT8703-10 for hinges, top cover and D3131-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM). \* 080618

4- Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-11. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF.) \* 080618

5- Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-12. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF). \* 080618

6- Ensure 17 1/16" from opposite edge of the door for Ø5/8" hole is in proper location top and bottom.

7- Drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert top and bottom. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA). \* 080618

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:53:19 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC5

INSPECT WORK TO CURRENT STEP



0806-19

N/A



PK

Comment: INSPECT WORK TO CURRENT STEP

4.0

8000528

Insert



Comment: Qty.: 21.0000 Each(s)/Unit Total: 21.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

Expiry Date:

M19443

M107007

090131

AS

080619

5.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).

2- Sand flush excess Hysol around the insert on both doors.

AS 080619

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

080626 (1)

7.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply primer filler and reducer around the inserts on both doors.

A/R 11045

Primer Filler

Batch:

108307

A/R 12375S

Reducer

Batch:

105936

ml 080626 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

080701 (1)

9.0

D31101

Escutcheon



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Escutcheon

Batch

B31752

JS 08/05/13

(X)

# Dart Aerospace Ltd

W/O: 39169D		Est: # 12357		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-07-07	3.0	Remove. QCS not necessary in this spot. perm. Change. <i>[Signature]</i>				<i>[Signature]</i> 08-07-07	<i>[Signature]</i> 08-07-07	

Part No: D412-694-04 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:53:19 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10.0	D31103	Handle
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Handle  
Batch 36724

JS 08/05/13 (XU)

11.0	D311041	Plate Assembly
------	---------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Plate Assembly  
Batch M10536-17

JS 08/05/13 (XU)

12.0	D31121	Guide
------	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Guide  
Batch 35234 35122

JS 08/05/13 (XU)

13.0	D31131	Spring
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Spring  
Batch 36725

JS 08/05/13 (XU)

14.0	D31141	Pivot
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pivot  
Batch 36726

JS 08/05/13 (XU)

15.0	D31165	Seal
------	--------	------



Comment: Qty.: 5.6700 f(s)/Unit Total : 5.6700 f(s)  
Seal 110-031-4  
Batch 27208

JS 08/05/13 (XU)

16.0	D311611	Seal
------	---------	------



Comment: Qty.: 1.5000 f(s)/Unit Total : 1.5000 f(s)  
SEAL  
Batch 24675

JS 08/05/13 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:53:19 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D3119042

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Cover Assembly  
Batch 3588127238

JS 08/05/13 (X)

18.0

D31202

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Cover, Flat Pattern  
Batch 17416

JS 08/05/13 (X)

19.0

D31204

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Cover  
Batch 17424

JS 08/05/13 (X)

20.0

D31251

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch 10536-17

JS 08/05/13 (X)

21.0

D31253

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch M10536-17

JS 08/05/13 (X)

22.0

D31255

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch M10536-17

JS 08/05/13 (X)

23.0

D31257

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lever  
Batch 10536-17

JS 08/05/13 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Friday, 09/05/2008 1:53:19 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D31291

Lever



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Lever

Batch

M1053617

JS 08/05/13 (X)

25.0

D31301

Clevis Base



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clevis Base

Batch

M10536-17

JS 08/05/13 (X)

26.0

D31311

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Stop

Batch

M10536-17

JS 08/05/13 (X)

27.0

D31341

Rod



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rod

Batch

27338

JS 08/05/13 (X)

28.0

D31344

Rod



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rod

Batch

29699

~~Batch~~  
in comp.

JS 08/05/13 (X)

29.0

D314008

Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Door Kit

Batch

39169C

JS 080724

30.0

D31431

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Clevis

Batch

M10536-17

JS 08/05/13 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:53:19 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

31.0	D31433	Clevis
------	--------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)  
Clevis M10536-17

JS 08/05/13 (X)

32.0	D3144117	Doubler
------	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Doubler  
Batch 22022

JS 08/05/13 (X)

33.0	D3144119	Doubler
------	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Doubler  
Batch 22023

Emp Sat  
No Qty But there is

JS 08/05/13 (X)

34.0	D3144121	Doubler
------	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Doubler  
Batch 22024

JS 08/05/13 (X)

35.0	D31452	Bracket
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Bracket  
Batch 31734

JS 08/07/24

36.0	D31462	Bracket
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Hinge Bracket  
Batch 26710

JS 08/05/13 (X)

37.0	D31471	Pin
------	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Pin  
Batch 30824

JS 08/05/13 (X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/05/2008 1:53:19 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

38.0	D31491	Striker Plate
------	--------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

Batch

M10536-17

JS 08/05/13 (X)

39.0	D31501	Guide
------	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch

M10536-17

JS 08/05/13 (X)

40.0	D31541	Key
------	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Key

Batch

B10536-17

JS 08/05/13 (X)

41.0	D31571	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

B10536-17

JS 08/05/13 (X)

42.0	D3159041	Bracket Assembly
------	----------	------------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

184041

JS 08/05/13 (X)

43.0	D3159044	Bracket Assembly
------	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

24087

JS 08/05/13 (X)

44.0	AN52510R7	Screw
------	-----------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M106166

JS 08/05/13 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/05/2008 1:53:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

AN960JD6L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch

5519

JS 08/05/13 (X)

46.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch

M107091

JS 08/05/13 (X)

47.0

AN960JD8L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch

M16956

JS 08/05/13 (X)

48.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch

M107715

JS 08/05/13 (X)

49.0

AN960JD10L

Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Washer

Batch

M104885

JS 08/05/13 (X)

50.0

AN960JD10LL

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total: 29.0000 Each(s)

Washer

Batch

M19600

JS 08/05/13 (X)

51.0

ALS463280

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Insert

Batch

17841

JS 08/05/13 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Friday, 09/05/2008 1:53:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

52.0	BSP45	Commercial Rivet
------	-------	------------------



Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)  
Commercial Rivet  
Batch M107296

AS 08/05/13 (X)

53.0	BSP46	Commercial rivet
------	-------	------------------



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)  
Commercial rivet  
Batch M101237

AS 08/05/13 (X)

54.0	FW4032	Washer
------	--------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Washer  
Batch M101203

AS 08/05/13 (X)

55.0	FW10032	Washer
------	---------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)  
Washer  
Batch M101203

AS 08/05/13 (X)

56.0	M7885344	Rivets
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Rivets  
Batch M19099

AS 08/05/13 (X)

57.0	M7885345	Rivet
------	----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Rivet  
Batch 1108

AS 08/05/13 (X)

58.0	MS203921C11	Pin
------	-------------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Pin  
Batch M18822

AS 08/05/13 (X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/05/2008 1:53:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

59.0

MS203922C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M14149

AS 08/05/13 (X)

60.0

MS203922C15

Pin



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pin

Batch

101340

AS 08/05/13 (X)

61.0

MS21042L3

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch

M107644

AS 08/05/13 (X)

62.0

MS21042L06

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M107898

AS 08/05/13 (X)

63.0

MS24665151

Cotter Pin



Comment: Qty.: 11.0000 Each(s)/Unit Total : 11.0000 Each(s)

Cotter Pin

Batch

M14526

AS 08/05/13 (X)

64.0

MS24694C4

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

M15924

AS 08/05/13 (X)

65.0

MS24694S53

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

M15798

AS 08/05/13 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/05/2008 1:53:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

66.0	MS24694S56	SCREW
------	------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
SCREW  
Batch M104467

AS 08/05/13 (XU)

67.0	MS24694S60	Screw
------	------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Screw  
Batch M104467

AS 08/05/13 (XU)

68.0	MS25281R6	Clamp
------	-----------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Clamp  
Batch 19098

AS 08/05/13 (XU)

69.0	MS27039106	Screw
------	------------	-------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Screw  
Batch M106815

AS 08/05/13 (XU)

70.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Screw  
Batch M106589

AS 08/05/13 (XU)

71.0	MS35206231	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw  
Batch 11735

AS 08/05/13 (XU)

72.0	MS35650305T	Nut
------	-------------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut  
Batch 11786

AS 08/05/13 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:53:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

73.0	MS518597	Washer
------	----------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch

M106421

AS 08/05/13 (XL)

74.0	NAS116910L	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

M11753

AS 08/05/13 (XL)

75.0	NAS38868P	Screw
------	-----------	-------



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Screw

Batch

M19098

AS 08/05/13 (XL)

76.0	NAS391B6P	Washer
------	-----------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

M19098

AS 08/05/13 (XL)

77.0	NAS43DD340	Spacer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

11737

AS 08/05/13 (XL)

78.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
------	----------------	--------------------



Comment: COMPOSITE ASSEMBLY

D412-694-04 Assembly Process

1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

AS 080724

2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB).

AS 080724

Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door.

3- Assemble Rod as per Dwg D412-694 page 5 (view W)

AS 080724

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

4- Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

*JA* 080730

5- Connect Rods and D3111-041 Plate Assembly as per Dwg D412-694 page 5 (view W).

*JA* 080731

6- Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x 100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg D412-694 page 5 (view W).

*JA* 080731

7- Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket. Drill Ø(#30) C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) and (section LL-LL).

*JA* 080731

8- Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.

*JA* 080731

9- Install (1) D3159-044 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler.

*JA* 080731

Note: Layout properly as per Dwg D412-694 page 5 (view W). Note: Second hole will be done with doubler and seal.

10- Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together. Note: Position strike plate when big door is in locked position.

*JA* 080731

11- Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3.

*JA* 080731

12- Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ)

*JA* 080811

13- Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC). Note: Install D3128-1 shim as required.

*JA* 080811

14- Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM).

*JA* 080811

15- Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3  
A/R RTV732 Clear Batch: 1108657 Expiry: 09 07 11

*JA* 080811

FOR D412-694-011 ONLY

16- Drill Pilot holes Ø(#1/8") for D3119-042 cover using drilling Jig D3119-042T1/T2 as per Dwg D412-694 page 3. Trim D3119-042 Cover Assembly and transfer Ø(#30) holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156).

*JA* 080811

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/05/2008 1:53:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169D

Part Number: D41269404

Job Number:



Seq. #:

Machine Or Operation:

Description :

17- Install D3119-042 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.

79.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

*Handwritten: 08.08.22*

80.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

(Put red label inside before putting the cover D3119-042/or Vip trim)

*Handwritten: 080826*

81.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Handwritten: 39169 u 08.08.25*

82.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten: 08/08/27*

Job Completion



*Handwritten: u 08.08.25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-694-01	DOOR ASSEMBLY
	X			D412-694-02	DOOR ASSEMBLY
		X		D412-694-03	DOOR ASSEMBLY
			X	D412-694-04	DOOR ASSEMBLY
		1	1	D3110-1	ESLUTOEON
		1	1	D3110-3	HANDLE
1	1			D3110-5	HANDLE ASSEMBLY
		1	1	D3111-041	PLATE ASSEMBLY
		2	2	D3112-1	GUIDE
		1	1	D3113-1	SPRING
		1	1	D3114-1	PIVOT
1	1			D3115-1	BRACKET
		1	1	D3116-11-0180	SEAL
		1	1	D3116-5-0680	SEAL
1	1			D3116-7-0680	SEAL
1	1			D3116-9-0770	SEAL
		1		D3119-041	COVER ASSEMBLY
		1	1	D3119-042	COVER ASSEMBLY
		1		D3120-1	COVER
		1	1	D3120-2	COVER
		1		D3120-3	COVER
		1	1	D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (ROLLER)
1				D3121-043	BRACKET ASSEMBLY (ROLLER)
	1			D3121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOCK
1	1			D3124-2	HOCK
		1	1	D3125-1	LEVER
		1	1	D3125-3	LEVER
		1	1	D3125-5	LEVER
		1	1	D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3126-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
		1	1	D3128-1	SHIM
		2	2	D3129-1	LEVER
		2	2	D3130-1	CLEVIS BASE
		1	1	D3131-1	STOP
1				D3132-041	ROD WELDMENT
	1			D3132-042	ROD WELDMENT
	1			D3133-041	ROD WELDMENT
1				D3133-042	ROD WELDMENT
		1	1	D3134-1	ROD
		1	1	D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
1				D3138-1	COVER
	1			D3138-2	COVER
1	1			D3139-1	GUARD
1				D3139-3	GUARD
	1			D3139-4	GUARD
1				D3140-05	DOOR
	1			D3140-06	DOOR
		1		D3140-07	DOOR
		1	1	D3140-08	DOOR
2	2			D3141-1	SPRING
		1	1	D3143-1	CLEVIS
		3	3	D3143-3	CLEVIS
		1		D3144-1	DOUBLER
1				D3144-3	DOUBLER
	1			D3144-105	DOUBLER
	1			D3144-107	DOUBLER
1				D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
	1			D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		1		D3146-1	HINGE BRACKET
		1		D3146-2	HINGE BRACKET
		2	2	D3147-1	PIN
2	2			D3148-1	CLEVIS
		2	2	D3149-1	STRIKER PLATE
		2	2	D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1				D3152-041	BRACKET ASSEMBLY
	1			D3152-042	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3156-1	BRACKET
		2	2	D3157-1	SPACER
		3	3	D3159-041	BRACKET ASSEMBLY
		1		D3159-043	BRACKET ASSEMBLY
		1		D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1		1		D3162-043	BRACKET ASSEMBLY
1		1		D3162-044	BRACKET ASSEMBLY
1				D3163-041	COVER ASSEMBLY
	1			D3163-042	COVER ASSEMBLY
1				D3183-041	BRACKET ASSEMBLY (ROLLER)
	1			D3183-042	BRACKET ASSEMBLY (ROLLER)
1	1			D3203-1	HANDLE ASSEMBLY
2	2			D3308-1	DOUBLER
55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
10	10			AN625-10R6	SCREW
8	8	4	4	AN625-10R7	SCREW
		8	8	AN660JD10	WASHER
18	18	4	4	AN660JD10L	WASHER
13	13	32	32	AN660JD10LL	WASHER
6	6			AN660JD416L	WASHER
		4	4	AN660JD6L	WASHER
6	6			AN660JD8	WASHER
		2	2	AN660JD8L	WASHER
		2	2	AN660JD8LL	WASHER
		10	10	ASL4-632-80	INSERT
87	87	50	50	BSP45	RIVET
		12	12	FW10-032	WASHER
		6	6	FW14-032	WASHER
12	12			M7885/24	RIVET (OR CR3213-4-3)
		3	3	M7885/34	RIVET (OR CR3212-4-3)
		2	2	MS20392-1C11	PIN
		7	7	MS20392-2C15	PIN
2	2			MS20392-2C17	PIN
2	2	2	2	MS20392-2C9	PIN
2	2			MS20392-3C21	PIN
8	8			MS20426AD3	RIVET
12	12			M7885/3-4	RIVET
8	3			MS20426AD4	RIVET

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AD4	RIVET
		6	6	MS21042L06	NUT
6	6	2	2	MS21042L08	NUT
		5	5	MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072-L3	NUTPLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24693-S271	SCREW
		2	2	MS24694-C4	SCREW
4	4			MS24694-C5	SCREW
6	6			MS24694-S5	SCREW
18	18			MS24694-S50	SCREW
		4	4	MS24694-S56	SCREW
		2	2	MS24694-S53	SCREW
		4	4	MS24694-S60	SCREW
4	4			MS24694-S68	SCREW
		2	2	MS25281-R6	CLAMP
2	2	2	2	MS27039-1-06	SCREW
14	14	12	12	MS27039-1-06	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS35205-231	SCREW
2	2			MS36275-233	SCREW
2	2			MS36649-264	NUT
		4	4	MS36650-305T	NUT
2	2			MS36650-3252	NUT
2	2	3	3	MS51859-7	WASHER
		4	4	NAS1169-10L	WASHER
		14	14	NAS388-6-8P	SCREW
		15	15	NAS391B6P	WASHER
7	7			NAS330D3-10	SPACER
6	6			NAS330D3-14	SPACER
		2	2	NAS330D3-40	SPACER

# GENERAL NOTES:

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOUT SHOWN IN VIEW N.
- IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEVIS BASE (REF. 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JIGS, E30-23000-01; D3144-T1/-T2/-T3; D18703-3; D3162-041T1 (FOR -01 DOOR ASSY); E30-23000-02; D3144-T7/-T8/-T9; D18703-9; D3162-041T2 (FOR -02 DOOR ASSY); D3144-T4/-T5/-T6; D3119-041T1; D3112-T1/-T2 (FOR -03 DOOR ASSY); D3144-T10/-T11/-T12; D3119-042T1; D3112-T1/-T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER DART QSI 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D412-694-01/-02/-03/-04 DOOR ASSEMBLIES USING D2729-1 DECALS.

CI	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	TITLE DOOR ASSEMBLY
DRAWING NO.	D412-694	REV. C
SHEET	1 OF 6	SCALE
		NTS

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

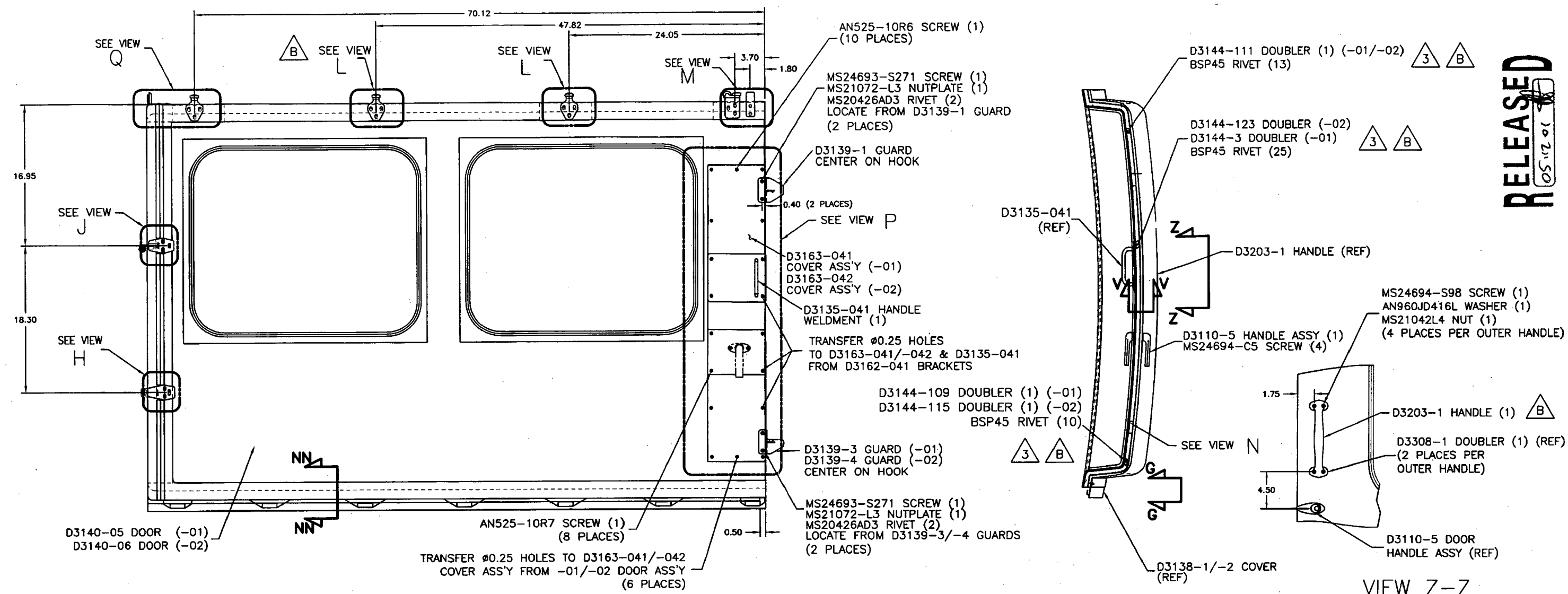
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 391690

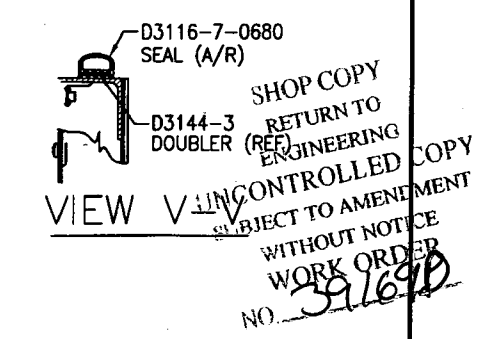
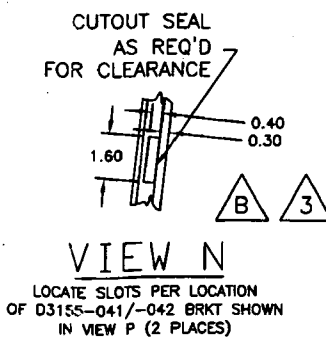
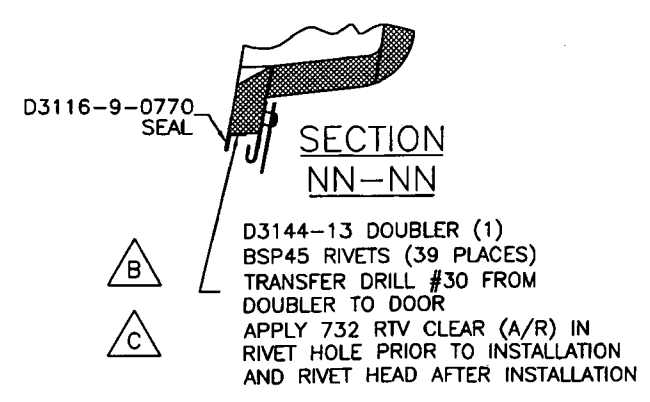
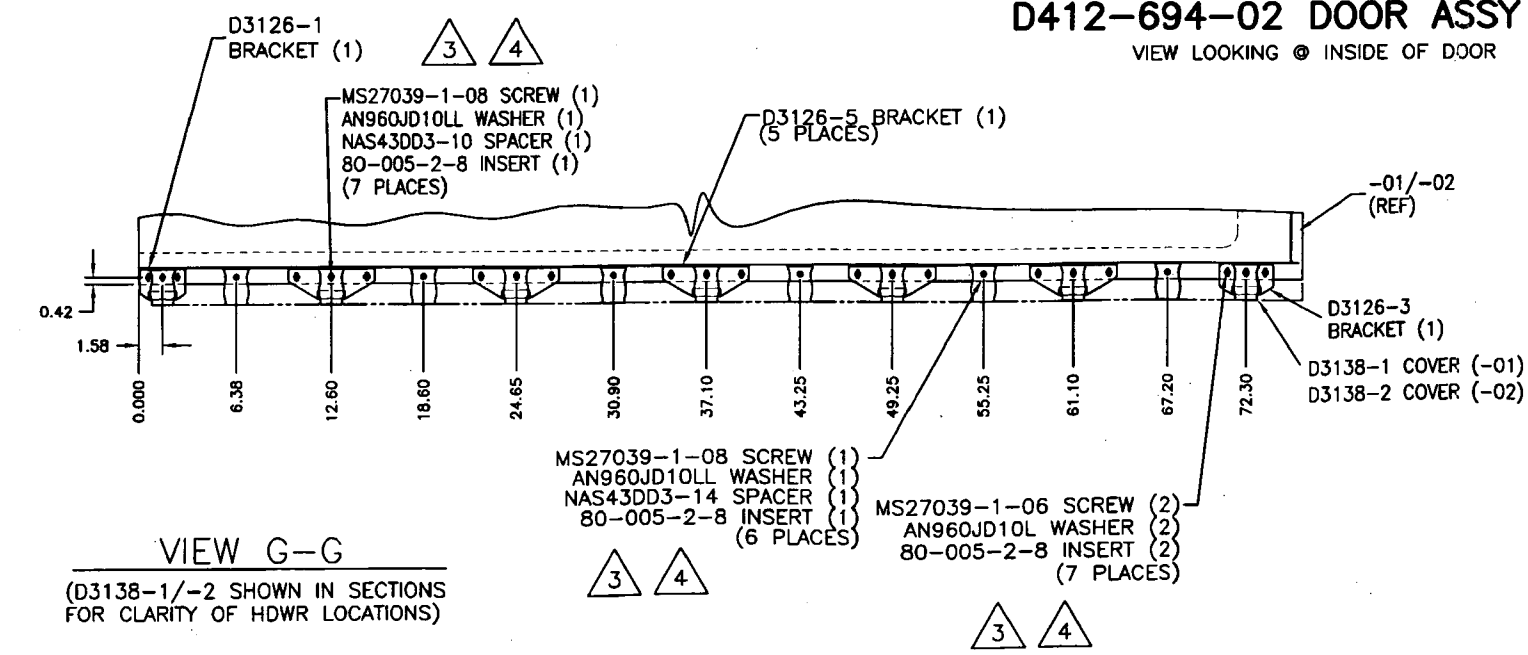
RELEASED

05.12.01-#

RELEASED  
05.12.01



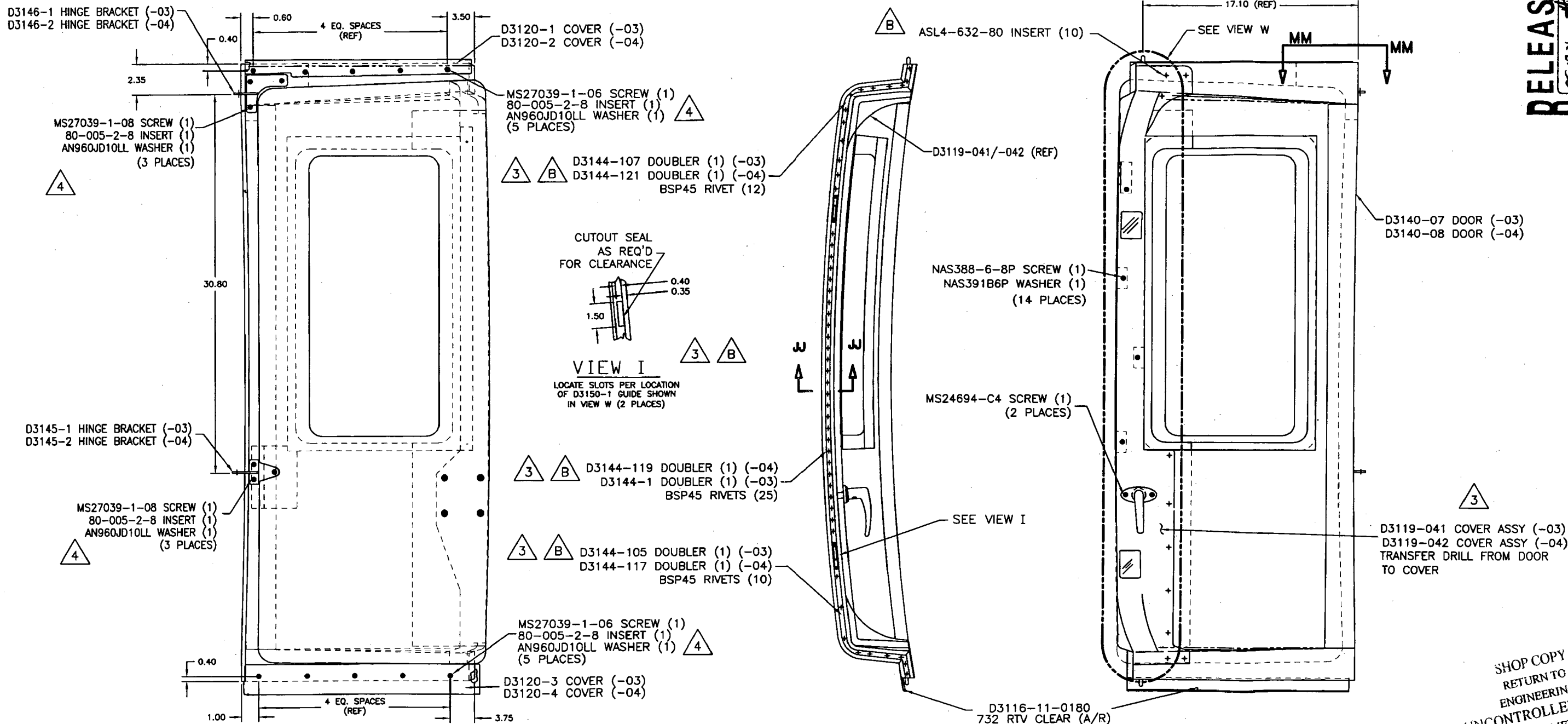
**D412-694-01 DOOR ASSY (SHOWN)**  
**D412-694-02 DOOR ASSY (OPP.)**  
 VIEW LOOKING @ INSIDE OF DOOR



COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CP	RF	DRAWING NO. D412-694	REV. C
		CHECKED	APPROVED	TITLE DOOR ASSEMBLY	SHEET 2 OF 6
		DATE 05.11.23		SCALE NTS	

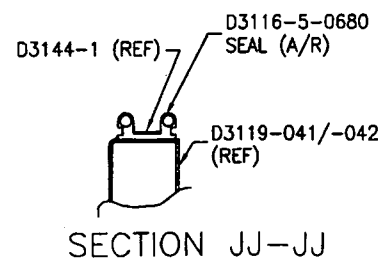
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39169D

RELEASED  
05-12-21



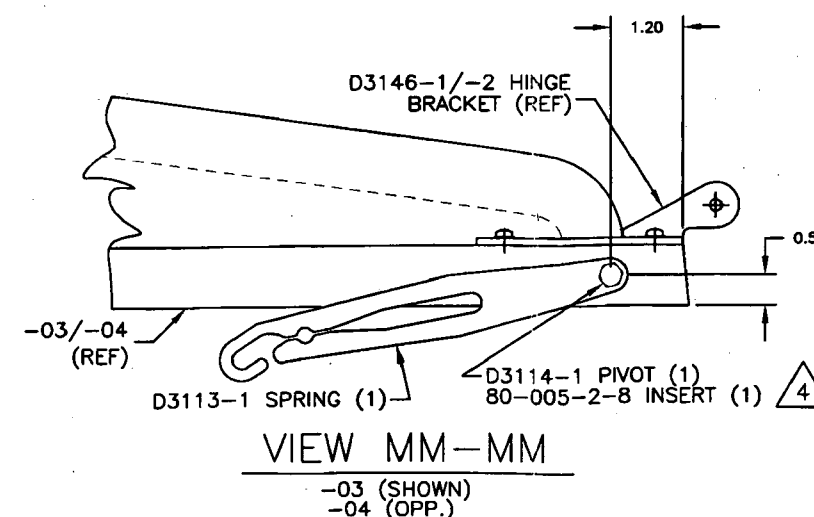
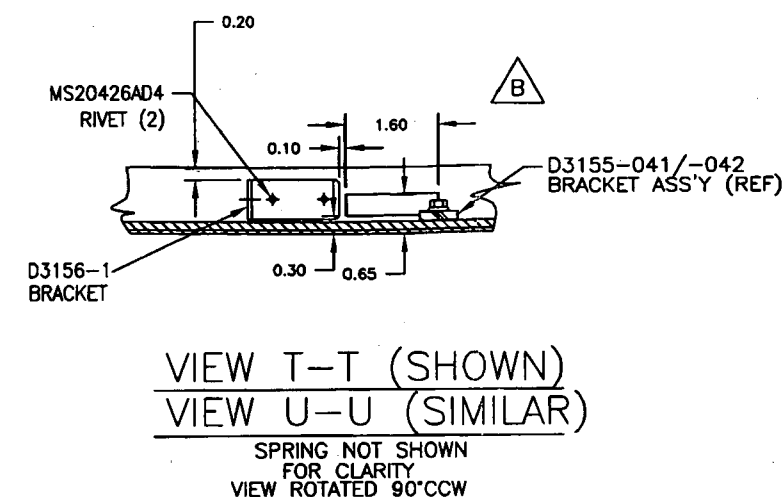
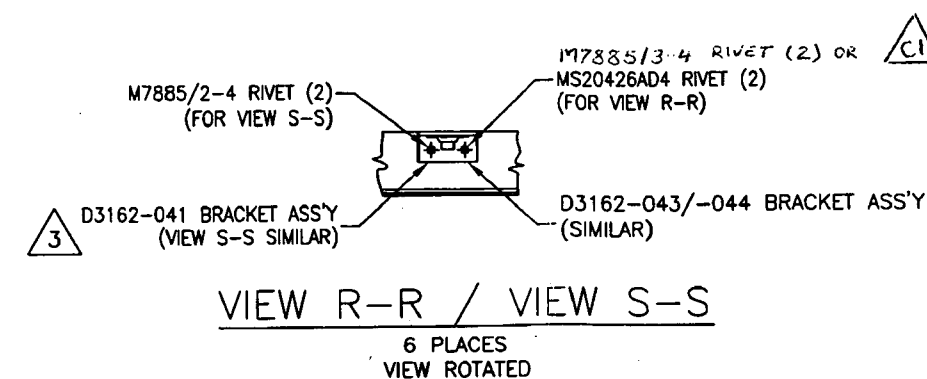
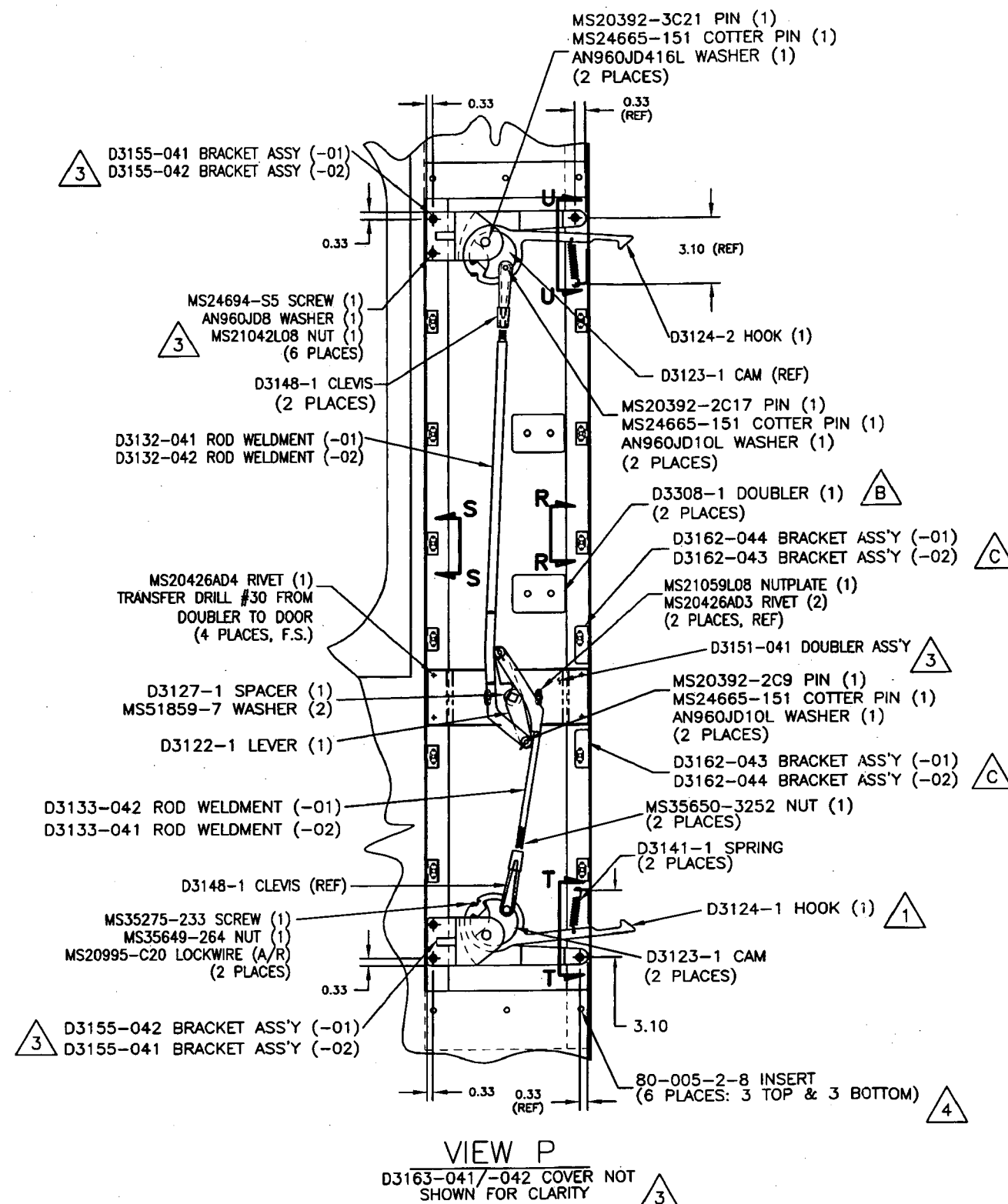
**D412-694-03 DOOR ASSY (SHOWN)**  
**D412-694-04 DOOR ASSY (OPP)**

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 39690



COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN CP	DRAWN BY RF	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED H6	APPROVED H6	DRAWING NO. D412-694	REV. C SHEET 3 OF 6
DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	

RELEASED  
05.12.01



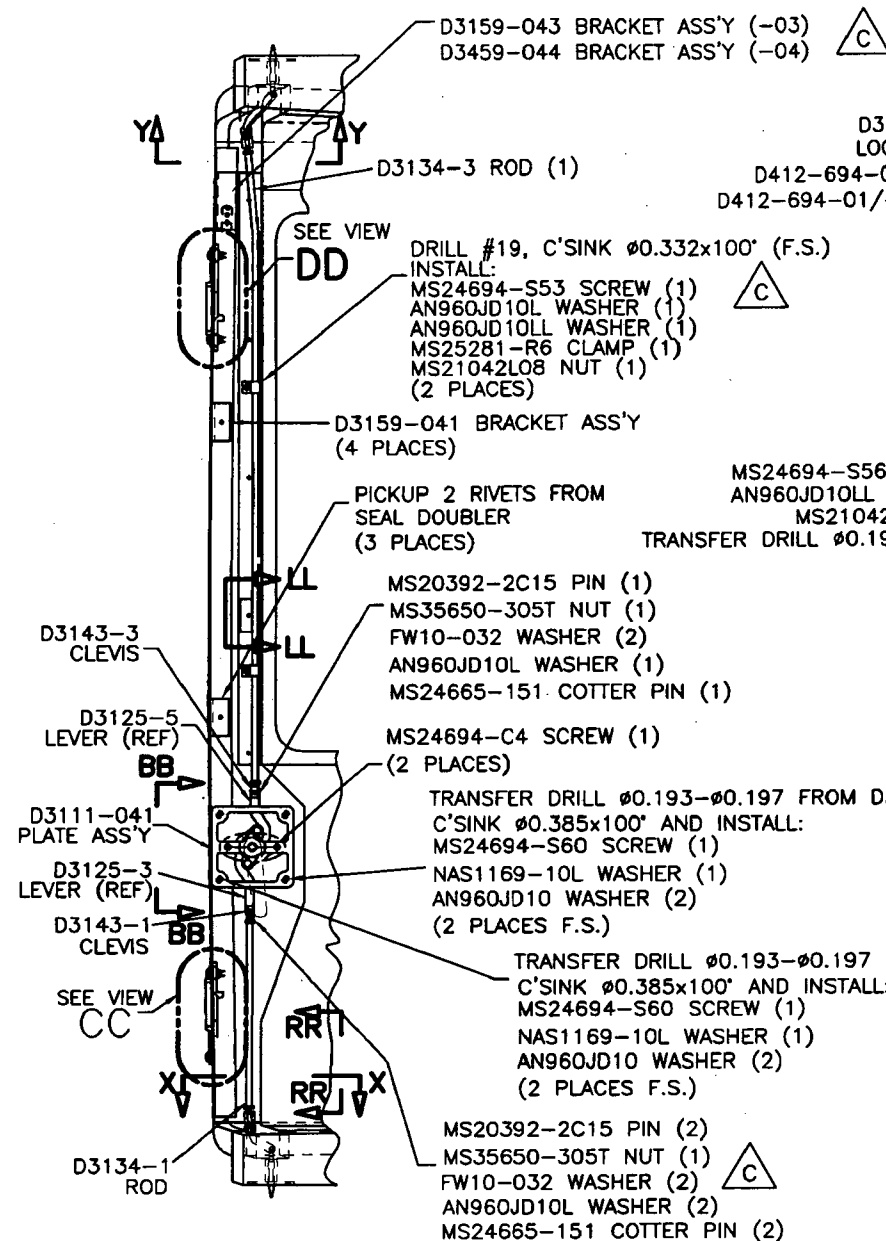
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 391690

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

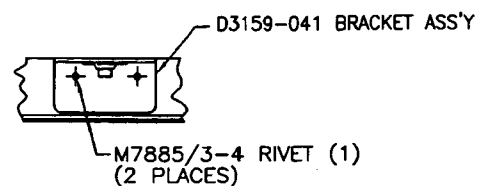
DESIGN CP	DRAWN BY RF	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D412-694	REV. C SHEET 4 OF 6
DATE 05.11.23	TITLE DOOR ASSEMBLY	SCALE NTS	





VIEW W

D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY  
SEAL ALSO NOT SHOWN FOR CLARITY



SECTION LL-LL  
(3 PLACES)  
VIEW ROTATED 90°CCW

D3150-1 GUIDE (1)  
LOCATE BY ALIGNING  
D412-694-03/-04 SLOTS IN  
D412-694-01/-02 CUTOUT A/R  
FOR CLEARANCE

D3128-1 SHIM (A/R)

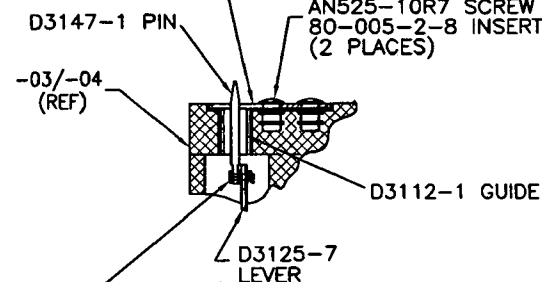
MS24694-S56 SCREW (1)  
AN960JD10LL WASHER (1)  
MS21042L3 NUT (1)  
TRANSFER DRILL  $\phi 0.191$  TO DOOR (2 PLACES)

VIEW DD  
VIEW CC (SIMILAR)

SEAL (REF)

D3149-1 STRIKER PLATE

RECESS DOOR FOR  
INSTALLATION OF  
D3112-1 GUIDE LEAVE  
0.040" AROUND D3112-1  
BRACKET TO ALLOW  
FOR ADJUSTMENT.  
FAIR IN FOAM USING  
HYSOL EA934 ADHESIVE



SECTION AA-AA

DRILL #10 ( $\phi 0.193$ )  
D3130-1 CLEVIS BASE (1)  
MS27039-1-06 SCREW (1)  
AN960JD10LL WASHER (1)

D3125-1 LEVER 0.80 (REF)

D3125-1 LEVER (TOP)  
D3125-7 LEVER (BOTTOM)

MS35650-305T NUT (1)

D3134-1/-3 ROD (REF)

D3143-3 CLEVIS

MS35206-231 SCREW (1)  
AN960JD6L WASHER (2)  
MS21042L06 NUT (1) (2 PLACES)

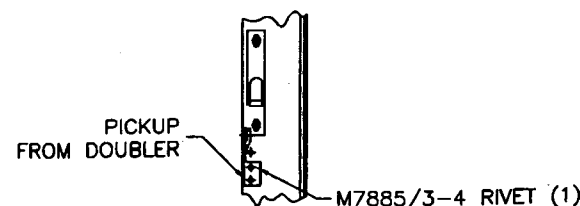
D3147-1 PIN (REF)

MS20392-1C11 PIN (REF)

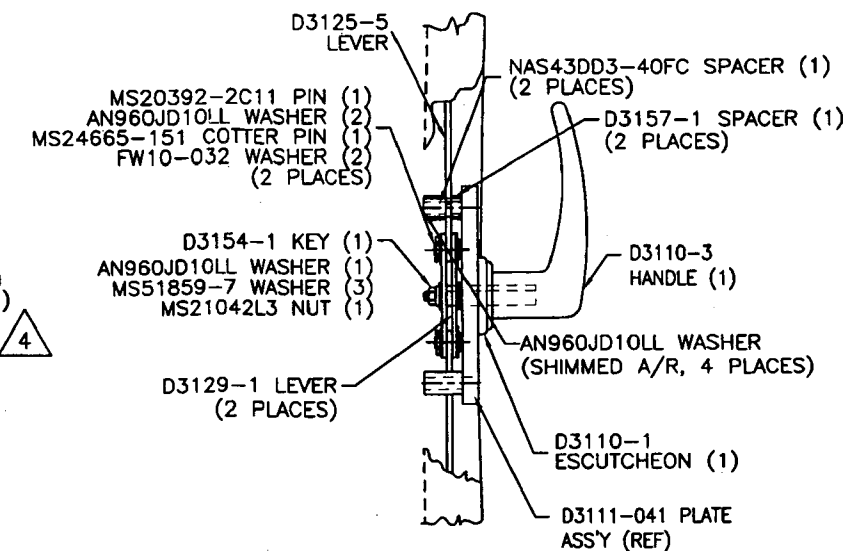
D3131-1 STOP  
MATCH DRILL D412-694-03/-04 (TOP ONLY)

MS20392-2C15 PIN (1)  
AN960JD10L WASHER (1)  
FW10-032 WASHER (2)  
MS24665-151 COTTER-PIN (1) (2 PLACES)

SECTION FF-FF

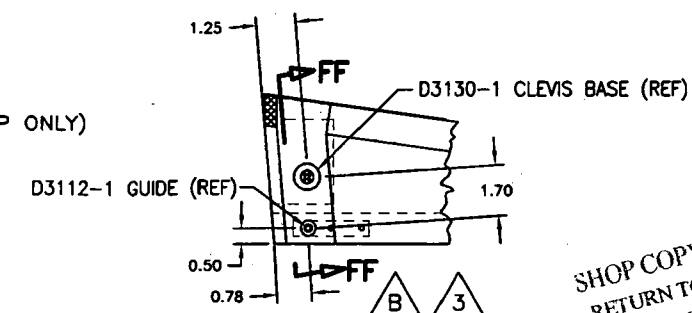


VIEW RR-RR



SECTION BB-BB

VIEW SHOWN WITH MECHANISM  
IN THE UNLOCKED POSITION  
FOR CLARITY



SECTION X-X (SHOWN)  
SECTION Y-Y (SIMILAR)

D3125-1 LEVER NOT SHOWN FOR CLARITY

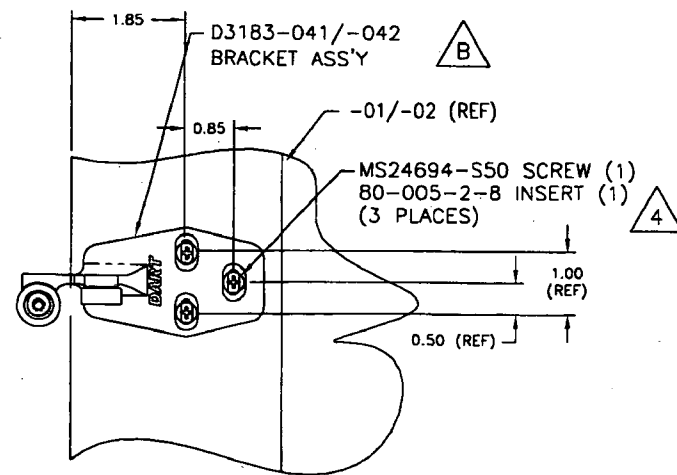
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 391690

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

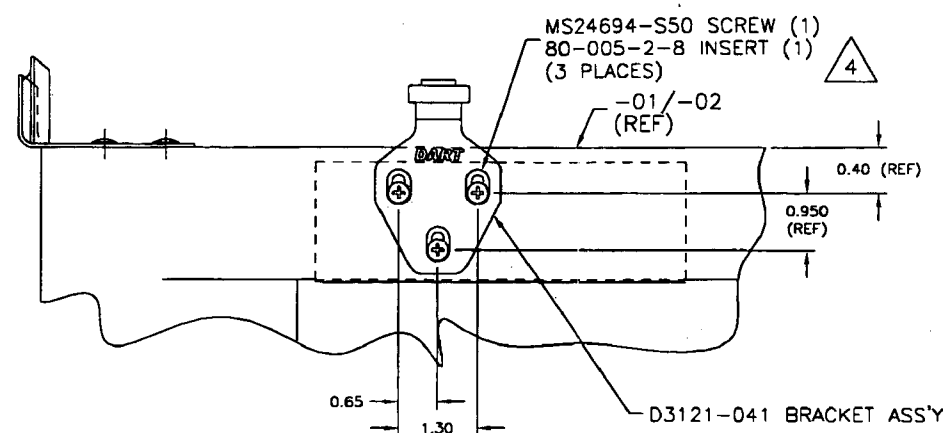
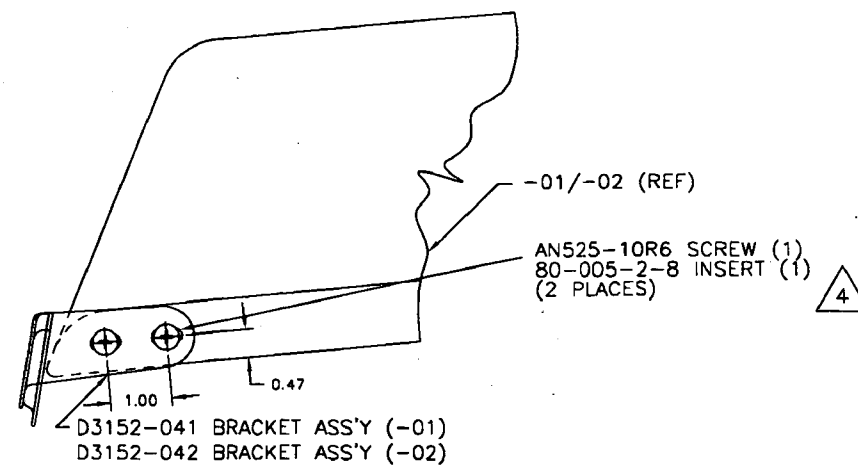
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DESIGN CP	DRAWN BY RF	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D412-694	REV. C SHEET 5 OF 6
DATE 05.11.23	TITLE DOOR ASSEMBLY	SCALE NTS	

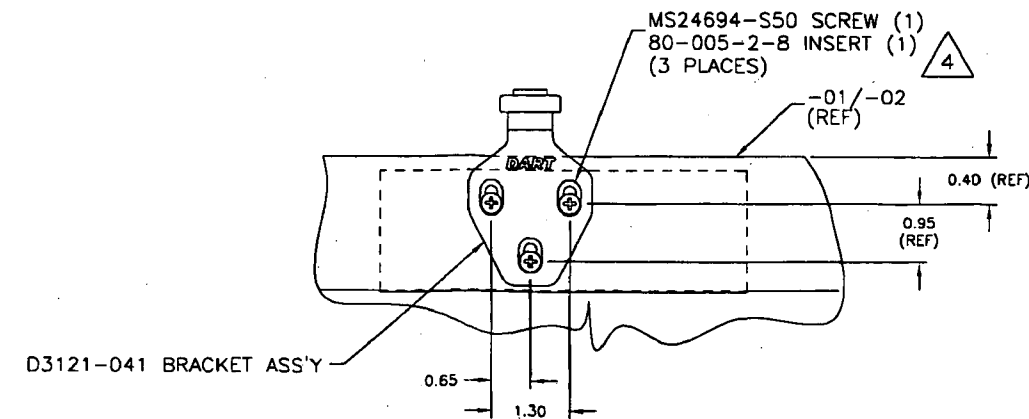
RELEASED  
05.12.01



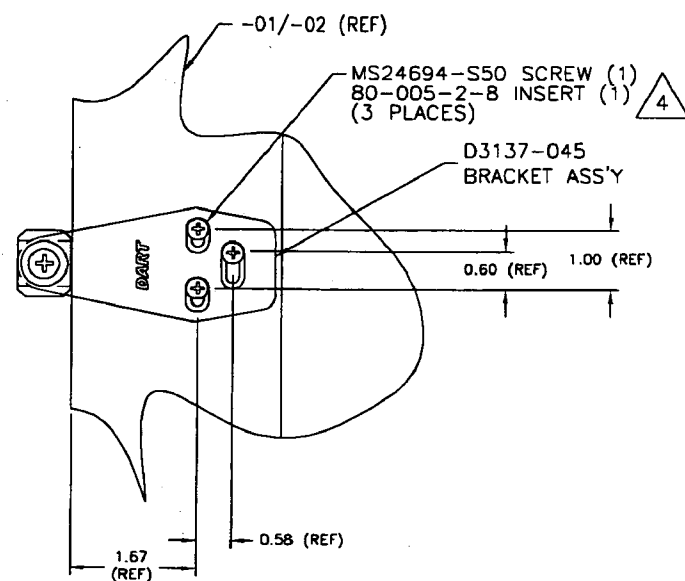
VIEW J



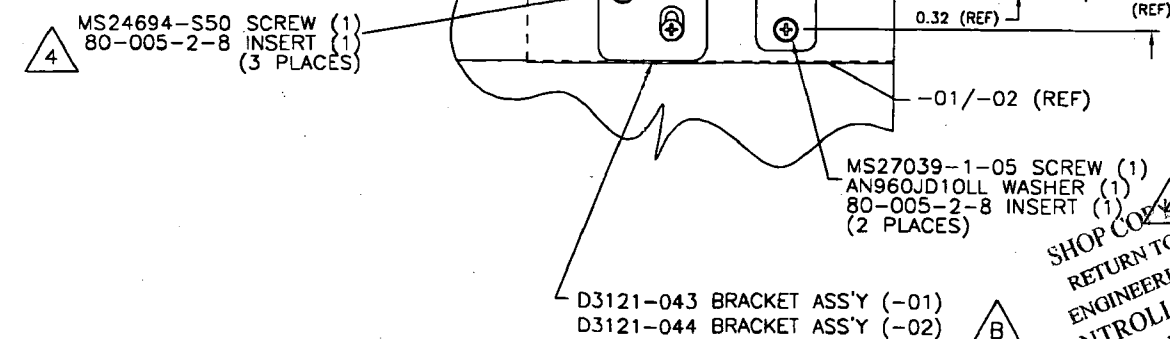
VIEW Q



VIEW L



VIEW H



VIEW M

RELEASED

05.12.01

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 391690

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DESIGN CP	DRAWN BY RF	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D412-694	REV. C
DATE 05.11.23	TITLE DOOR ASSEMBLY		SHEET 6 OF 6 SCALE NTS



DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12639
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
28/04/2008	08/06/2006	4699	C. Lavoie		PO00001429		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC135-0019	D3140-06 Door Right Non Assy ( Grosse ) Job: 42212			
1	0	1	DKC135-0020	D3140-08 Door Right Non Assy ( Petite ) Job: 42212			
1	0	1	DKC135-0017	D3140-05 Door Left Non Assy ( Grosse ) Job: 42210			
1	0	1	DKC135-0018	D3140-07 Door Left Non Assy ( Petite ) Job: 42210			
<div>Revised Approved work order</div>							

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:


Quality department

AQ-357



Date: Jeudi, 2007-10-04 08:59:53  
 Utilisateur: Marc Dubé

## Feuille de Procédé

Client : DART Dart Aerospace Ltd.	Nom Dessin : DOOR	 17-01- 9.S.
Numéro Job : 42210	Numéro Article : <del>DKC135-0008/0000</del> DKC135-0017	
Numéro Soumission : 1725	Numéro Dessin : D3140	
Numéro B.A. :	Projet Numéro : DKC135	
Cette fois : 2007-10-04 No. B.V. :	Révision dessin : F	
Prsht Rev. : NC	Matériel : Tissu Fibercote E-761/7788	
Prem. fois : - - - Type :	Date Dûe : 2007-10-11 Qté: 1 Udm: UNITE	
Job précédente : 42209		



Écrit par : \_\_\_\_\_

Vérifié &amp; Approuvé par : \_\_\_\_\_

 Commentaires : N° de pièce Dart Aerospace: D3140-05/07  
 N° de pièce Delastek Aeronautique: DKA359-0008/-0009  
 N° de pièce Delastek Composites: DKC135-0008/-0009

 Process Sheet Rév.: 11 Changer la révision de dessin pour la Rév.:  
 F

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	OUTILLAGE	OUTILLAGE NÉCESSAIRE À LA FABRICATION
-----	-----------	---------------------------------------


 Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
 OUTILLAGES NÉCESSAIRES À LA FABRICATION DE LA PIÈCE

 Moule N° B30-23000-01T  
 Patron de découpe N° B30-23000-57T  
 Patron de découpe N° B30-23000-61T  
 Patron de découpe N° B30-23000-63T  
 Patron de découpe N° B30-23000-71T  
 Patron de découpe N° B30-23000-73T  
 Patron de découpe N° B30-23000-75T  
 Patron de découpe N° B30-23000-77T  
 Patron de découpe N° B30-23000-79T  
 Gabarit de taillage N° B30-23000-05T ( 2 pièce ) et N° B30-2300-03T  
 Forme de silicone N° B30-23000-07T

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------


 Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
 PRÉPARATION DU MOULE

Préparation du moule selon la section 5.0 de l'instruction de travail TEC-77

Quantité: 1 Date: 15-11-07 Sceau:



Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Numéro Job: 42210

Nom Dessin: DOOR

Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

3.0 AMB0211

PREPERG FIBERCOTE E761/7781 roul. 50"

Commentair Qty.: 12.3 VERGE(s)/Unit Total : 12.3 VERGE(s)  
PREPERG FIBERCOTE E761/7781 roul. 50"

N° de Lot: 1-6293-1

4.0 PRÉPARATION 2

PRÉPARATION MATÉRIEL PLASTIC COMMERCIAL



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
DÉCOUPAGE MATÉRIEL

Découpe du tissu pré-imprégné e-761 paquets de 10.5 pi². ( 7 paquets =24.5 Verges )

Quantité: 1 KIT Date: 16-11-07 Sceau:



5.0 DRAPAGE 1

DRAPAGE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs  
DRAPAGE DES PIECES

Faire le drapage de 3 plis de tissu pré-imprégné e-761 ( 4 Paquets ) selon la section 8.1.1 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 16-11-07 Sceau:



6.0 AC0409

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)  
Tissu à délaminer Release ply B

7.0 AC0407

Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)  
Wrightlon 5200 Bleu P3

8.0 AC0408

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)  
Feutre de drainage N° Airweave N 10

9.0 AC0755

Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total : 7.770 METRE CAR(s)  
Sac à vide N° Stretchlon 700

10.0 AC0098

Ruban à gommer jaune #: T/IAT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total : 2.0000 RL(s)  
Ruban à gommer jaune #: T/IAT-200Y

Date: Jeudi, 2007-10-04 08:59:53

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42210

Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

11.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.1 de l'instruction de travail N° TEC-77.

Quantité: 1

Date: 16-11-07

Sceau:



12.0

CUISSON 1

CUISSON PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
CUISSON DES PIECES

Faire la cuisson selon la section 8.3.1 de l'instruction de travail N° TEC-77

Inscrire le N° de cuisson: 5736

Quantité: 1

Date: 16-11-07

Sceau:



13.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
DÉMOULAGE DES PIECES

Retirez le montage cuisson et faire les retouches de la pièce, afin d'enlever les surplus de résines et les résidus de tissu à délaminer.

Quantité: 1

Date: 19-11-07

Sceau:



14.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
INSPECTION GÉNÉRALE

Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: 1

Date: 19-11-07

Sceau:



Date: Jeudi, 2007-10-04 08:59:53  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42210

Nom Dessin: DOOR  
Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.: Machine ou Opération: Description :

15.0 ACP0006 Rohacell 71S 1"thick 49.2" x 98.4" plain

Commentair Qty.: 2.00 UNITE(s)/Unit Total: 2.00 UNITE(s)  
Rohacell 71S 1"thick 49.2" x 98.4" plain

N° de Lot: 1-6290-1

16.0 DÉCOUPE DÉCOUPAGE PRIMAIRE



Commentair Setup: 0.00Hrs/ Run: 360.0000Min Total Run: 6.0000Hrs  
DÉCOUPAGE PRIMAIRE

Faire la découpe des pièces de mousse structurales ( Rohacell ) sur la scie à ruban selon la section 8.1.2 de l'instruction de travail N° TEC-77.



Quantité: 1-Kit Date: 20-11-07 Sceau:

17.0 SÉCHAGE SÉCHAGE DU MATÉRIEL



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
SÉCHAGE DU MATÉRIEL

Faire le séchage du Rohacell selon les informations du manufacturier

Inscrire le N° de cuisson: 5737

Quantité: 1 Date: 19-11-07 Sceau: E/R



20-11-07

18.0 AAC0560 FILM ADHESIF PF-7035-C

Commentair Qty.: 55 UNITE(s)/Unit Total: 55 UNITE(s)  
FILM ADHESIF PF-7035-C

N° de Lot: 1-6534-1 EH: 15/08/2008

19.0 ACP0003 Core splice adhesive MA560.048

Commentair Qty.: 5 UNITE(s)/Unit Total: 5 UNITE(s)  
Core splice adhesive MA560.048

N° de Lot: 1-6292-1

20.0 AAC0563 EPOCAST 87269-A/B

Commentair Qty.: 0.25 KIT(s)/Unit Total: 0.25 KIT(s)  
N/A ~~EPOCAST 87269-A/B~~ P-17

N° de Lot: 1-19854-1

Date: Jeudi, 2007-10-04 08:59:53

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42210

Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.: Machine ou Opération: Description :

21.0 AAC0644 DOUBLER KIT D3140-5-7

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) 1-6408-1

DOUBLER KIT D3140-5-7

1-6375-2, 1-6309-04, 1-6309-4, 1-6421-1

N° de Lot: 1-6492-2, 1-6492-3, 1-6492-1, 1-6492-4

22.0 NETTOYAGE 3 NETTOYAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

NETTOYAGE GÉNÉRALE

Faire le nettoyage des doublers selon l'instruction générale N° I.G. # Lavage pièce aluminium traité alodine.

Quantité: 1 Date: 4-04/08 Sceau:

Quantité: Date: Sceau:

23.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run: 3.0000Hrs

ASSEMBLAGE GÉNÉRALE DES PIÈCES

Mise en place des doublers et des pièces de mousse structurales selon la section 8.1.3 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 8/10/08 Sceau:



24.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)

Tissu à délaminer Release ply B

25.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)

Wrightlon 5200 Bleu P3

26.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)

Feutre de drainage N° Airweave N 10

27.0 AC0755 Sac à vide N° Strechlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total: 7.770 METRE CAR(s)

Sac à vide N° Strechlon 700

28.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total: 2.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y



Date: Jeudi, 2007-10-04 08:59:53  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42210

Nom Dessin: DOOR  
Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.: Machine ou Opération: Description :

29.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.2 de l'instruction de travail N° TEC-77

Quantité: 1 Date: 8/04/08 Sceau:

30.0 CUISSON 1 CUISSON PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
CUISSON DES PIECES

Faire la cuisson des pièces selon la section 8.3.2 de l'instruction de travail N° TEC-77

5770

Quantité: 1 Date: 8/04/08 Sceau:

31.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
DÉMOULAGE DES PIECES

Retirez le montage cuisson de sur la pièce, et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium, Garder seulement la barre qui sépare les deux pièces.

Quantité: 1 Date: 4/04/08 Sceau:

32.0 DÉCOUPE CORE DÉCOUPE DU CORE DART



Commentair Setup: 0.00Hrs/ Run: 210.0000Min Total Run : 3.5000Hrs  
USINAGE DES MOUSSE

Usinage des mousses sturcturales selon la section 8.1.4 de l'instruction de travail N° TEC-77

Quantité: 1 Date: 4/04/08 Sceau:

33.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
INSPECTION GÉNÉRALE

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.

Date: Jeudi, 2007-10-04 08:59:53  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42210

Nom Dessin: DOOR  
Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.: Machine ou Opération:

Description :

Quantité: 1 Date: 5-4-08 Sceau:

34.0 AMB0211

PREPERG FIBERCOTE E761/7781 roul. 50"

POUR REJEAN CHAMPAGNE

Commentair Qty.: 12.3 VERGE(s)/Unit Total: 12.3 VERGE(s)  
PREPERG FIBERCOTE E761/7781 roul. 50"

N° de Lot: 1-20139-1

35.0 DRAPAGE 1

DRAPAGE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run: 3.0000Hrs  
DRAPAGE DES PIECES

Drapage de la coquille intérieur selon la section 8.1.5 de l'instruction de travail N° TEC-77

Quantité: 1 Date: 5/4/08 Sceau:

36.0 AC0409

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)  
Tissu à délaminer Release ply B

37.0 AC0407

Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)  
Wrightlon 5200 Bleu P3

38.0 AC0408

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)  
Feutre de drainage N° Airweave N 10

39.0 AC0755

Sac à vide N° Strechlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total: 7.770 METRE CAR(s)  
Sac à vide N° Strechlon 700

40.0 AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total: 2.0000 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

41.0 POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run: 2.0000Hrs  
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.3 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 5/4/08 Sceau:

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42210

Nom Dessin: DOOR  
Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.: Machine ou Opération: Description :

42.0 CUISSON 1 CUISSON PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
CUISSON DES PIECES

Faire la cuisson de la pièce selon la section 8.3.3 de l'instruction de travail N° TEC-77.

5807

Quantité: 1 Date: 5/04/08 Sceau:

43.0 DÉMOLAGE 1 DÉMOLAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
DÉMOLAGE DES PIECES

Retirez le montage cuisson, et faire de retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer.

Retirer la pièce du moule.

Quantité: 1 Date: 7/04/08 Sceau:

44.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
TRIMAGE DE FINITION

Faire le trimage de finition de la pièce selon la section 8.5 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 10/04 Sceau:

45.0 AAC0671 Dupont Primer N° 1104S

77045

Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6473-2

46.0 AAC0670 Dupont Activator N° 7975S

77755

Commentaire Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-6473-1

47.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: N/A

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42210

Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.: Machine ou Opération: Description :

48.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
PRÉPARATION DU MATÉRIEL

APR 16 2008



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

49.0 INSPECTION 3 INSPECTION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
INSPECTION PIÈCE DART

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel "

Date: 16-4-08

Sceau:



Initiales:

N.S.

50.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART

Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
APPLICATION DE PRIMER

Appliquer une épaisse couche de primer partout sur les deux portes.

Quantité: 1

Date: APR 16 2008

Sceau:



51.0 FINITION 3 FINITION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  
FINITION GÉNÉRALE

Faire un sablage léger ( Grit 320-400 ) de toute les surfaces.

Quantité: 1

Date: 21-04-08

Sceau:



52.0 AAC0671 Dupont Primer N° 1104S

7704S

Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)

Dupont Primer N° 1104S N° de Lot: 1-C-473-2

53.0 AAC0670 Dupont Activator N° 7975S

7775S

Commentaire Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)

Dupont Activator N° 7975S N° de Lot: 1-C-473-1

Date: Jeudi, 2007-10-04 08:59:53

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42210

Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

54.0

AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total: 0.1250 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: N/A

55.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
PRÉPARATION DU MATÉRIEL

APR 24 2008

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

56.0

PEINT/ PRIMER2

PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
APPLICATION DE PRIMER

Application d'une couche de primer de finition partout sur les deux portes.

Quantité: 1

Date: APR 24 2008

Sceau:

57.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
IDENTIFICATION DES PIECES

Identifier le numéro de la pièce, le numéro de job ainsi que la date de fabrication sur l'aluminium peinturé dans le dégagement des mécanisme de porte.

Grosse porte : D3140-05

Petite Porte: D3140-07

Quantité: 1

Date: APR 24 2008

Sceau:

58.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
INSPECTION GÉNÉRALE

Inspection finale par le département de la qualité selon le dessin D3140.

Date: 25-4-08

Sceau:

Initiales: N.S.

Date: . . . Jeudi, 2007-10-04 08:59:53

Utilisateur: \* Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42210

Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

59.0

EMBALLAGE 3

EMBALLAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

EMBALLAGE ET ENTREPOSAGE

Faire l'emballage selon la section 8.7 de l'instruction de travail N° TEC-77

Quantité: 1 Date 25-04-08 Sceau: \_\_\_\_\_

